

Date: Monday, 4/10/2006 11:14:08 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER INLET ADAPTER
 Job Number : 26613
 Estimate Number : 12317
 P.O. Number : N/A Part Number : D3473041
 This Issue : 4/10/2006 S.O. No. : N/A Drawing Number : D3473 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : 26174 Material : N/A
 Written By : SKP COMMENT Below Due Date : 4/28/2006 Qty: 1 Um: Each
 Checked & Approved By : 06.04.10
 Comment : Est Rev. A New Issue 06-03-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3473043 BLOWER INLET WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3473-043 INLET ADAPTER

B26614

SB 06/04/27 ⑤

2.0 D34709 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3470-9 Bolt

B26387

SB 06/04/27 ⑤

3.0 AN960416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 4 AN960-416 Washer

M5519

SB 06/04/27 ⑤

4.0 AN3104 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 AN310-4 Nut

M19356

SB 06/04/27 ⑤

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06CH27		AN3-3A	M100117	x 30 ⁶	} Assembly pieces	FF	06.04.27	30 ⁰⁵	06CH27
		AN960-10	M5519	^ 30 ⁴		FF	06.04.27	30 ⁰⁵	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26613

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS24665136

Cotter Pins



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS24665-136 Cotter Pin 112421

SB 06/04/27

⑤

6.0

D3474041

Inlet valve shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3474-041 Inlet valve shaft B26387

SB 06/04/27

⑤

7.0

MS35206217

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35206-217 Screw M19402

SB 06/04/27

⑤

8.0

AN9604L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-4L Washer M14606

SB 06/04/27

⑤

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26613

Part Number: D3473041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 NAS679A04 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 NAS679A04 Nut M.100551

SB 06/04/27 (5)

10.0 D34747 BUTTERFLY VALVE SEAL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3474-7 Valve Seal B26713

SB 06/04/27 (5)

11.0 D34745 BUTTERFLY VALVE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3474-5 Valve Plate B26123

SB 06/04/27 (5)

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3473

Ensure that Valve Assembly Opens & Closes Smoothly

SB 06/04/27 (5)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/27 (5)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 06/04/27 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 26613

Part Number: D3473041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Handwritten: D 06/04/08 (S)

Job Completion



Handwritten: u 06-04-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr		Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

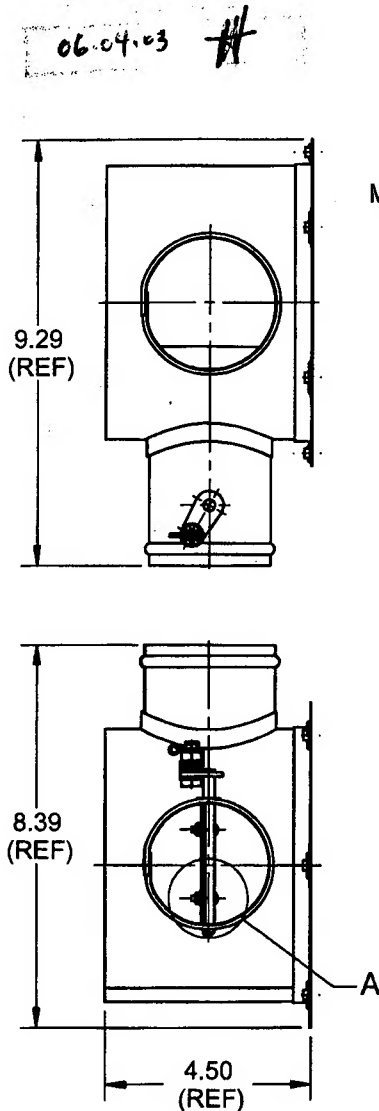
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

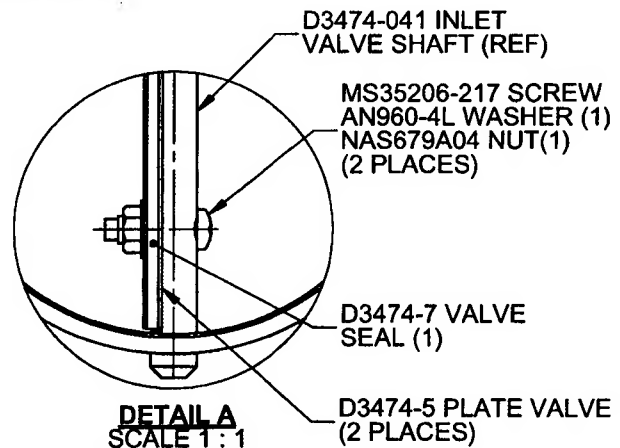
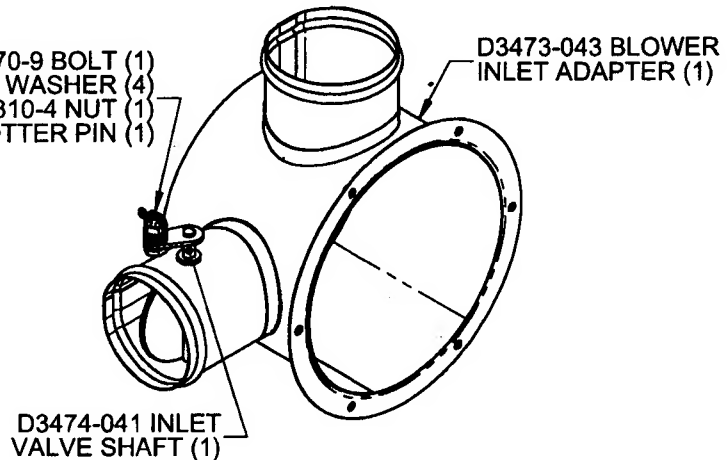
NOTE: Date & initial all entries

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3473	REV. A SHEET 1 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	



D3470-9 BOLT (1)
AN960-416 WASHER (4)
AN310-4 NUT (1)
MS24665-153 COTTER PIN (1)



D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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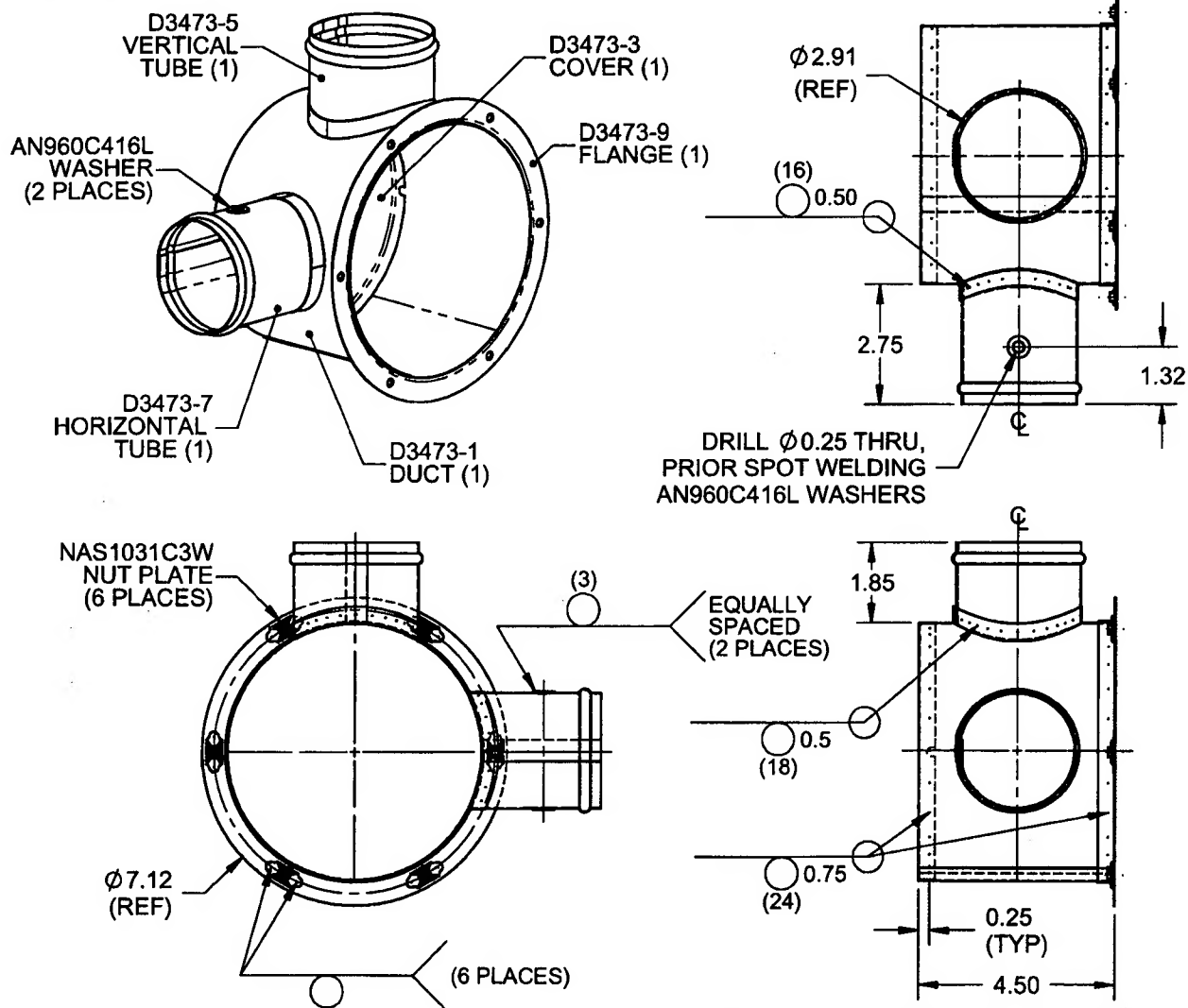
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CHECKED H	APPROVED H	DRAWING NO. D3473	REV. A SHEET 2 OF 7
DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED

06.04.03

**D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

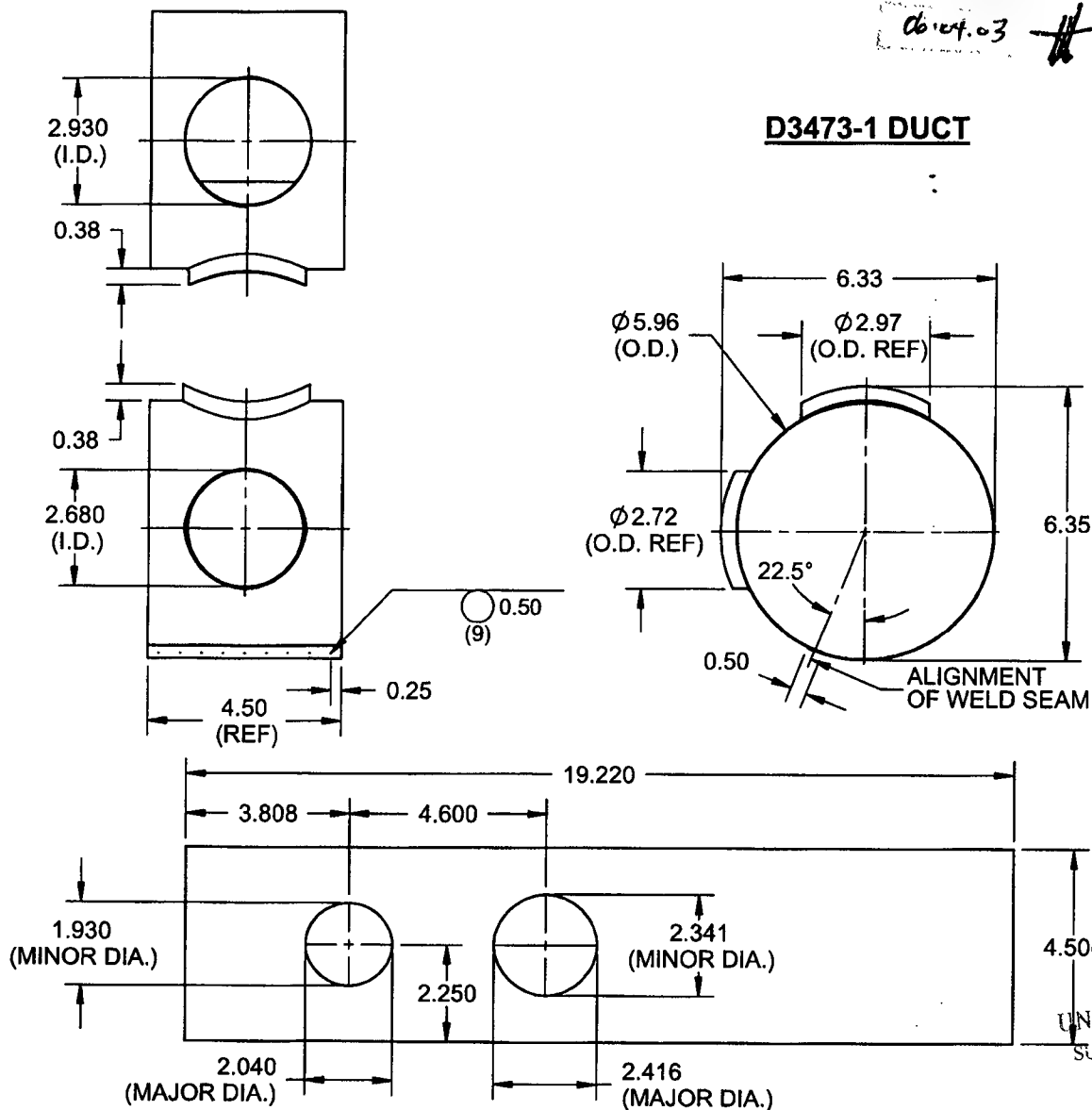
QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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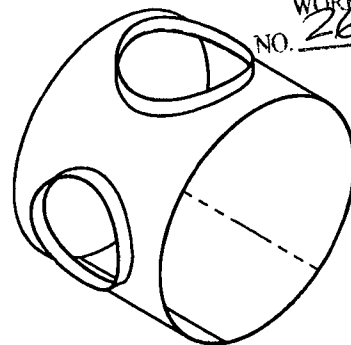
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:4

**D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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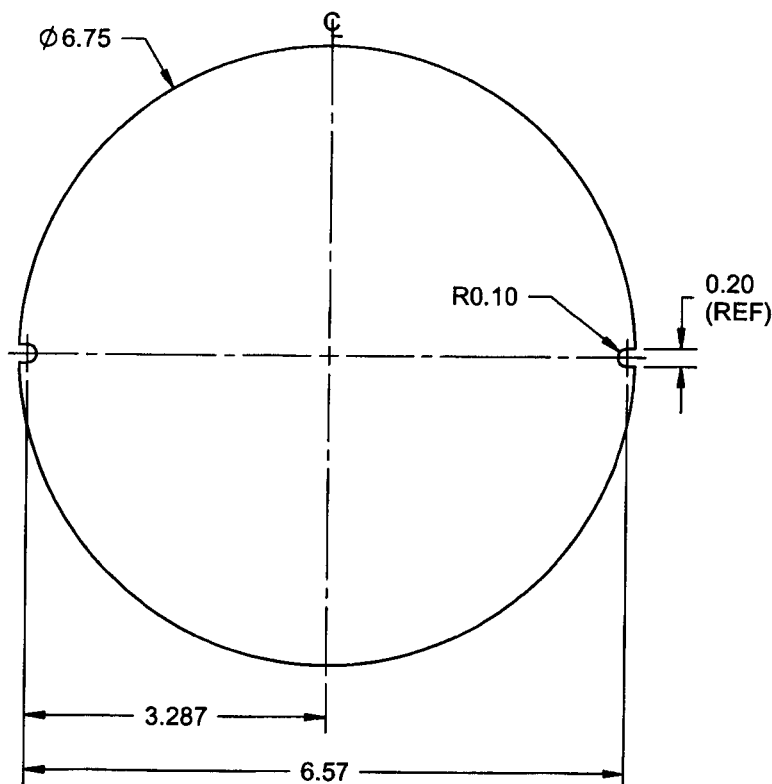
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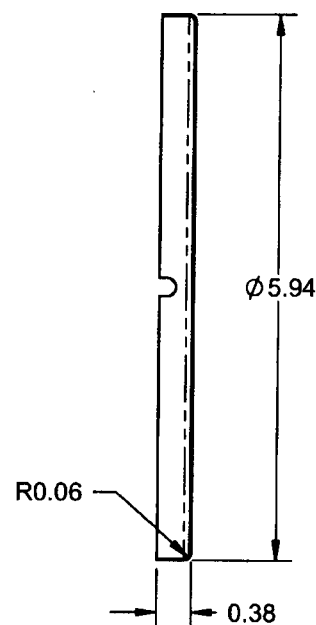


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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2

06-04.03



D3473-3F COVER FLAT PATTERN



D3473-3 COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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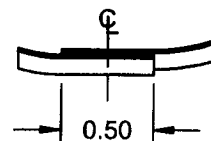
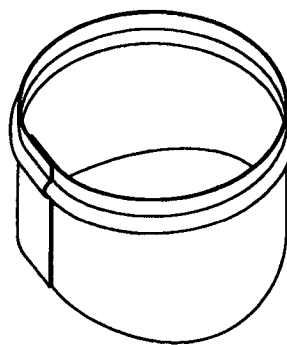
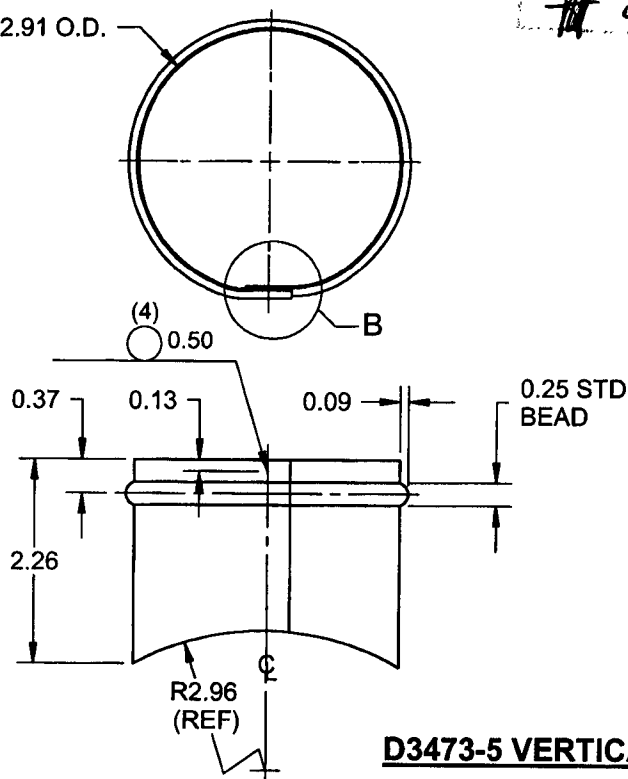
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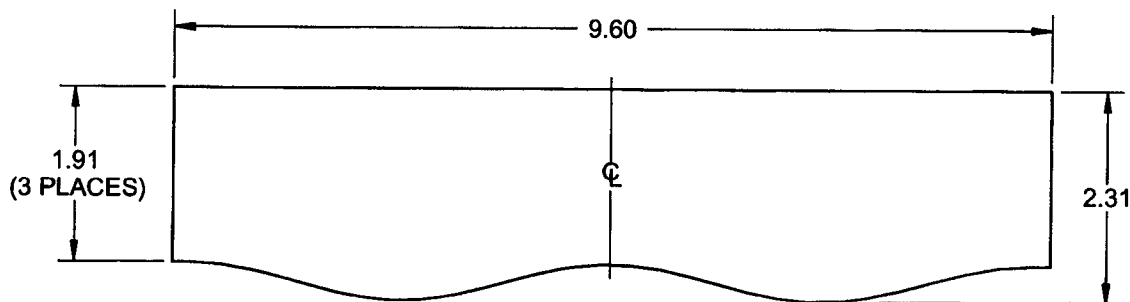
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2

Ø2.91 O.D.



DETAIL B
SCALE 1:1

D3473-5 VERTICAL TUBE



D3473-5F VERTICAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

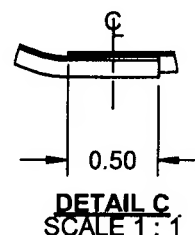
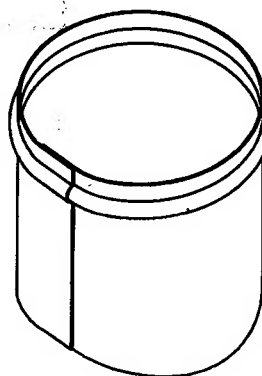
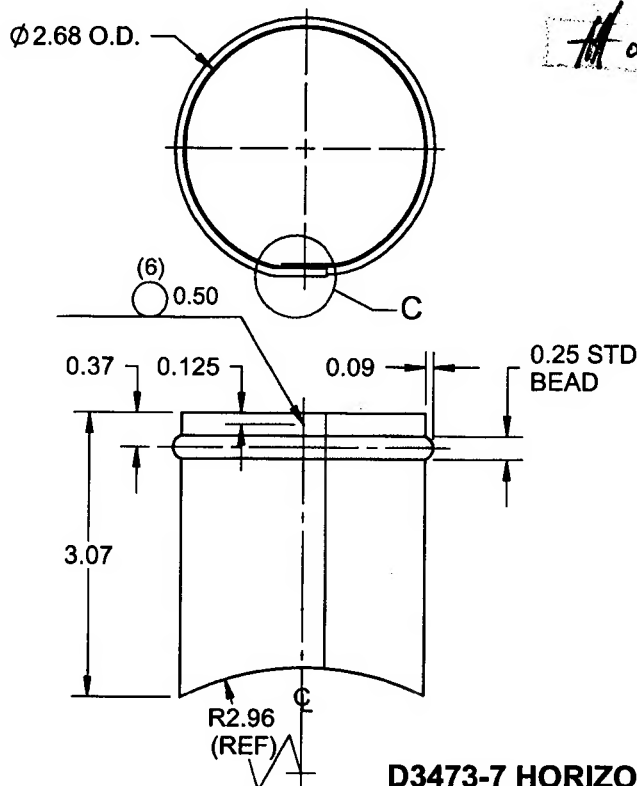
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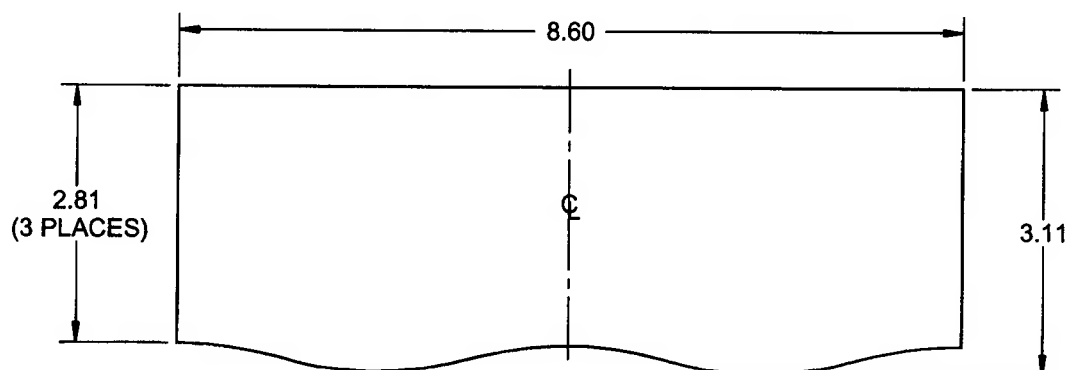
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-7 HORIZONTAL TUBE



D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

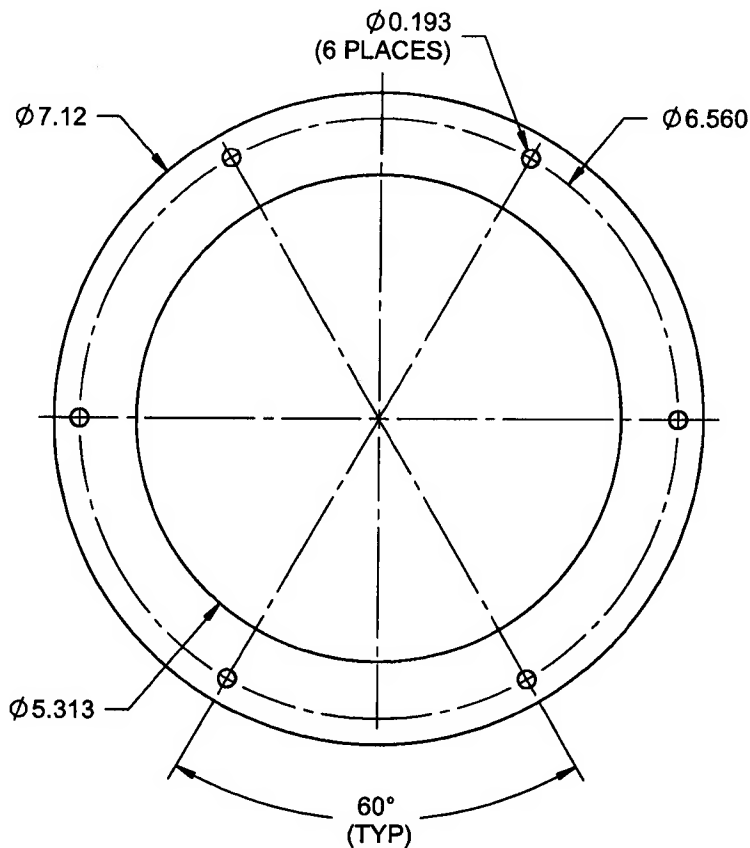
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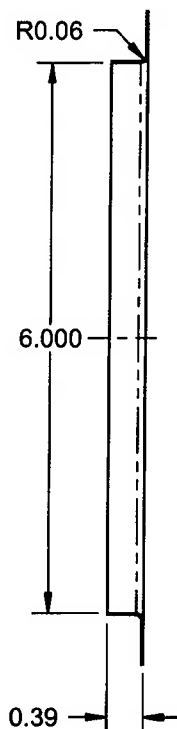
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DATE 06.02.07		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3473-9F FLANGE FLAT PATTERN



D3473-9 FLANGE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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